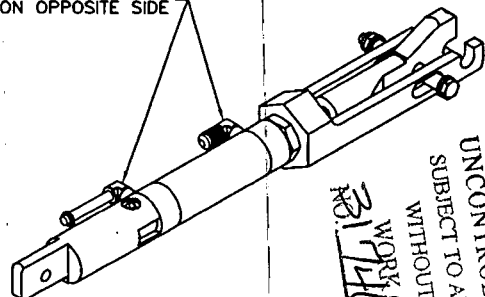


INSTALL ITEM #12  
ON OPPOSITE SIDE



-002 R/H ACTUATOR ASSY

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 317469  
A

- ④ TORQUE 80-100 IN.-LB.  
③ TORQUE 20-25 IN.-LB.  
② TORQUE 50-75 IN.-LB.  
① TORQUE 50-75 IN.-LB.

NOTES:

			1	1	15	3/4x20 BRASS	CYLINDER NUT																
			1	1	14	MS20322-4	ELBOW																
			1	1	13	AN842-4D	ELBOW																
			1	1	12	41232-200-007-001	CYLINDER																
			1	1	11	71459	SPRING																
			1	1	10	MS16996-23	CAP SCREW																
			1	1	9	AN315-4R	NUT																
			2	2	8	AN960JD416	WASHER																
			2	2	7	AN960JD10	WASHER																
			1	1	6	MS21042-L3	NUT																
			1	1	5	AN3-22A	BOLT																
			2	2	4	41232-200-005-003	SPACER																
			1	1	3	41232-200-002-005	PIVOT ARM																
			1	1	2	41232-200-002-003	LATCH																
			1	1	1	41232-200-002-001	TUBE																
						-002	R/H ACTUATOR ASSY																
						-001	L/H ACTUATOR ASSY																
			-002	-001	FND NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE												
NO. REQ'D PER ASSY												LIST OF MATERIAL											
<b>PROPRIETARY RIGHTS NOTICE</b> <small>THESE DATA ARE PROPRIETARY TO ERA AVIATION, INC. DISCLOSURE, REPRODUCTION OR USE OF THESE DATA FOR ANY PURPOSE IS PROHIBITED WITHOUT WRITTEN AUTHORIZATION FROM ERA AVIATION, INC. THE FOREGOING DOES NOT APPLY TO SOURCE PARTS.</small>												UNLESS OTHERWISE SPECIFIED X ± .1 XX ± .03 XXX ± .010 ANGLES ± .1°	DRAFTSMAN	D. NELSON	5/20/02	TITLE STEP ACTUATOR ASSY							
													CHECK	D. MURPHY	5/20/02								
													STRESS			DWG. SIZE	C	SCALE	NONE				
													PROJ. ENGR.										
													HEAT TREAT										
FINISH							Era Aviation, Inc.					DWG. NO.	41232-200-001	REV.	IF								
-002-001												41232-000-001											
GAIN NO.												NEXT ASSEMBLY											

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 4/12/2007 8:53:03 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH ACTUATOR ASSEMBLY

Job Number: 31746

Part Number: 41232 200 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

1207105/17

Job Completion



u of 05.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				0			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/17

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:53:03 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH ACTUATOR ASSEMBLY

Job Number: 31746

Part Number: 41232 200 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

41232 200 002 005

pivot arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pivot arm

Batch: B 31778

○

14.0

41232 200 002 003

latch



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

latch

Batch: B 31777

SB 07/05/15

③

15.0

41232 200 002 001

tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

tube

Batch: B 31776

SB 07/05/15

③

16.0

41232 200 008 001

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Decal

Batch: M 31023

SB 07/05/15

③

17.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg 41232-200-001

2-Torque as per Dwg 41232-200-001

SB 07/05/15

③

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FA05-17 ③

19.0

PACKAGING 1

PACKAGING RESOURCE #1


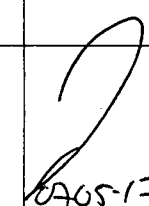


Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/05/17 ③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/05/15		2 Spring 51455 Batch M104079 Part E Ragon Batch M104251 on spring	SB	07/05/15	3	 07.05.15	 07.05.17

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:53:03 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH ACTUATOR ASSEMBLY

Job Number: 31746

Part Number: 41232 200 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS1699623

cap screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
cap screw

Batch: M103934

SB 07/05/15 ③

7.0

AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Nut

Batch: M17564

SB 07/05/15 ③

8.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Washer

Batch: M102929

SB 07/05/15 ③

9.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Washer

Batch: M100743

SB 07/05/15 ③

10.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Nut

Batch: M104215

11.0

AN322A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bolt

Batch: M3413

SB 07/05/15 ③

12.0

41232 200 005 003

Spacer (Step Actuator)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Spacer (Step Actuator)

Batch: B31022

SB 07/05/15 ③

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/05/11	11	Split W/O	SB	07/05/11	3			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 4/12/2007 8:53:03 AM  
User: Kim Johnston

Process Sheet

split  
SB 07/05/11

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RH ACTUATOR ASSEMBLY  
Job Number : 31746  
Estimate Number : 12770  
P.O. Number : N/A Part Number : 41232 200 001 002  
This Issue : 4/12/2007 S.O. No. : N/A Drawing Number : 41232-200-001 REV IR  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : IR  
Previous Run : 31451 Material : N/A  
Written By : Due Date : 5/10/2007 Qty: 4 Um: Each  
Checked & Approved By : 07/04/12  
Comment : Est Rev:A New Issue 07-02-28 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MS208224 elbow



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) stock

elbow X

Batch: M103688 (2) M104427 (1)

SB 07/05/11 (3)

2.0 124K002 4CR 0545 Hose ass'y-Step Actuator



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hose ass'y-Step Actuator

BATCH: part of packing kit u

3.0 AN8424D Elbow



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Elbow

Batch: M104156

SB 07/05/11 (3)

4.0 41232 200 007 001 Brass Cylinder Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Brass Cylinder Assembly

Batch: B 30942 (2) B 30946 (1) left over (3)

5.0 41232 200 003 001 Spring (Step Actuator)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spring (Step Actuator)

Batch: part of packing kit u